

Date:  
User:Tuesday, 26/02/2008 1:40:15 PM  
Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 37626 *-2*  
 Estimate Number : 13140  
 P.O. Number :  
 This Issue : 26/02/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL / MED FAB  
 Previous Run : 37626

Drawing Name : HOOP  
 Part Number : D37251  
 Drawing Number : D3725 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 07/03/2008

Qty: 10 Um: Each

Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 08-01-30 new issue DD verified by:EC  
 Est Rev:B 08-02-26 change to rev.A verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0625X3000 304 BAR .625 X 3.00



Comment: Qty.: 0.4375 f(s)/Unit Total: 4.3754 f(s)  
 304 stainless steel bar .625"x 3.00"  
 (M304B0625X3000)  
 Batch: *107078* *IB 8-2-27*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3725  
 Dwg Rev: *A*  
 Prog Rev: *A*

*IB 8-2-27**DEBURR IB 8-2-27*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Make chamfer by hand as per dwg D3725

2- Deburr

*Pd 08.03.05**(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 10 Date: 08/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/03	H 20	one parts scan hole was elongated PC Human/machine malfunc		Scanned Defect No Rep/see Qty (4)	08/03/03	08/03/03		08/03/03

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOP

Job Number: 37626

Part Number: D37251

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/03/05 (2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS-22*

*CP 08-03-05*

*(2)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(2) 08/03/06*

Job Completion



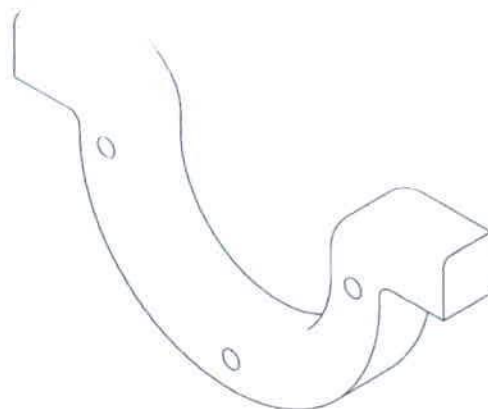
*mini 2008/3/05*

*(2)*

*(P2) 7*







D3725-1 HOOP

NO. 37626  
 37626  
 UNCONTROLLED COPY  
 RETURN TO  
 ENGINEERING  
 SUBMIT TO AGREEMENT  
 WITHOUT NOTICE

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
 (REF. DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

RELEASED  
 1E 08-02-25

A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	N/S		
DRAWN			
CHECKED	1E		
MFG. APPR.	N/S		
APPROVED			
DE APPR.			
DATE	08.01.28		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3725</b>	REV. A SHEET 1 OF 2
TITLE <b>HOOP</b>	SCALE NTS

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TOLERANCE REQUIRED  
FLAT PORTION OF PART  
ONLY

0.622<sup>+0.000</sup>  
-0.015

Ø0.194 THRU  
3 PL

R0.50  
4 PL

0.38 X 45° CMF  
2 PL

R0.13  
2 PL

R1.75

**D3725-1 HOOP**

R0.10 - R0.20  
2 PL

0.622<sup>+0.000</sup>  
-0.015

TOLERANCE REQUIRED  
FLAT PORTION OF PART  
ONLY

2.56  
REF

RELEASED  
DATE 08.02.25

NO 31624  
REWORK OFFICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DESIGN	JS	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	LE	D3725	SHEET 2 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	HOOP	NTS
DATE	08.01.28	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	





03725-

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**X**

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[illegible]

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9-2-27

5

05/02/03

4

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Approved

